



MAR 09 2018
Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-604-041
Job Sheet 173756



Part No: D350-604-041

Job Qty: 1 ea

Part Name: Rear Locker Extender



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No: Was job #156640 - route change

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D350-604-041 REV C ~~WAS~~ D2273 REV M IPP Rev:Q 03.12.01 Reformat KJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM IPP REV:X 17.01.12 AS PER CHG010 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	1 pcs		3/15/18	0.00	0.00	Purchasing		18/03/18
120	Packaging	1 pcs		3/15/18	0.00	0.00	Packaging2		18/03/18
130	QC	1 pcs		3/15/18	0.00	0.00	QC6		38
140	Small Fab	1 pcs		3/16/18	0.00	0.17	Small Fab-4		MAR 18 2018
150	QC	1 pcs		3/16/18	0.00	0.00	QC5		58
155	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging1-3		APR 18 2018
158	QC	1 pcs		3/16/18	0.00	0.00	QC4		58
159	DC	1 pcs		3/16/18	0.00	0.00	DC		58
160	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3-1		APR 18 2018
170	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		APR 18 2018

Part Op 110 - Issue P/O: 03200 Description: D350-604-041 Rear locker extender. Manufacture as per dwg D2273 Supplier: FDC Composites Inc. Certification of Conformity and process sheet required. ***EXTREME CARE MUST BE TAKEN TO

PROTECT THE SURFACES OF THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.*** ***MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE***

120 - Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached. ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

130 - Check hole locations to template. DT 8824 Check process sheet and audit.

140 - 1- INSTALL DECALS AS PER DWG (D2728-1)

155 - ***DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM***

159 - Photocopy bluefile and create labels per PPP D350-604-041 CHG0010

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-604-041P	Rear Locker Extender	1 Ea (1 ea)	110-Purchasing	
D2268	Placard D2268P	1 Ea (1 ea)	140-Small Fab	#164003
D2269	Placard	1 Ea (1 ea)	155-Packaging	5035985
D5062-041	Bracket Assembly	1 Ea (1 ea)	155-Packaging	5005898



Rear Locker Extender

PART NO: D350-604-041

Serial No/Batch: S048521

Revision:

Operation: Packaging

Change No: CHG010

Mfg Date: 03/06/18

Job No: 173756

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D350-604-041P	1	4	0
140-Small Fab	D2268	1	15	0
155-Packaging	D2269	1	13	0
	D5062-041	1	8	0
Part Specifications				
Specifications could not be found.				

Plex 3/6/18 3:36 PM Dart.Gagnon.Michelle



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO35200

Supplier: FDC001-VC
FDC Composites Inc.
45 chemin de L'Aéroport , Local 26
St-Jean-sur-Richelie
QC
J3B 7B5 Canada
Phone: 450-357-1344 ext303
Fax: 450-357-1194

PO No: PO35200
PO Date: 2/3/17
Due Date: 12/14/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Pynt Terms: net 30

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D350-604-041P	-	Rear Locker Extender		Firmed	12/14/17	1 Ea	0 Ea	1 Ea	\$705.00/Ea	\$705.00
2	D350-604-041P	-	Rear Locker Extender		Firmed	12/14/17	1 Ea	0 Ea	1 Ea	\$705.00/Ea	\$705.00
3	D350-604-041P	-	Rear Locker Extender		Firmed	12/14/17	1 Ea	0 Ea	1 Ea	\$705.00/Ea	\$705.00
4	D350-604-041P	-	Rear Locker Extender		Firmed	12/14/17	1 Ea	0 Ea	1 Ea	\$705.00/Ea	\$705.00
5	D350-604-041P	-	Rear Locker Extender		Firmed	12/14/17	1 Ea	0 Ea	1 Ea	\$705.00/Ea	\$705.00

Grand Total: \$3,525.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/6/17 1:08 PM Dart.Baker.Diane



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-604-041
Job Sheet 156640



see job 173756

Part No: D350-604-041

Job Qty: 1 ea

Part Name: Rear Locker Extender



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 12/14/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Rilpa Enterprises Ltd (CRILP01)

480 Aviation Way NE Calgary, AB, T2E 7G3 Canada ph:(403) 275-3035 fx:(403) 730-0170.

Note: DWG D350-604-041 REV C U/R, D2273 REV M IPP Rev:Q 03.12.01 Reformat KJ/RF IPP REV:R 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM IPP REV:X 17.01.12 AS PER CHG010 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	12/13/17	0.00	0.00	Start up container	
100	DC	1 pcs	12/13/17	0.00	0.00	DC	
110	Purchasing	1 pcs	12/13/17	0.00	0.00	Purchasing	
120	Packaging	1 pcs	12/13/17	0.00	0.00	Packaging2	
130	QC	1 pcs	12/13/17	0.00	0.00	QC6	
140	Small Fab	1 pcs	12/14/17	0.00	1.61	Small Fab	
150	QC	1 pcs	12/14/17	0.00	0.00	QC5	
155	Packaging	1 pcs	12/14/17	0.00	0.00	Packaging1	
158	QC	1 pcs	12/14/17	0.00	0.00	QC4	
160	Packaging	1 pcs	12/14/17	0.00	0.00	Packaging3	
170	QC21-FG	1 Ea	12/14/17	0.00	0.00	QC21	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D350-604-041P	1	0	0	0
140-Small Fab	D2268	1	7	0	0
	D2728-1	1	0	0	0
155-Packaging	D2269	1	1	0	0
	D5062-041	1	4	0	0

Part Specifications

Specifications could not be found.

Work Order ID 156640

Friday, February 03, 2017 1:00:04 PM

156640

Page 1

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 11/16/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 13 5-59 Date: FEB 03 2017

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2273

M

D350-604-041

C U/R

OK d'18/4/23

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-604-041
CHG0010

110

PURCHASING

0.00

110

Purchasing

Memo

0.00

Purchasing

Issue P/O: 35200

Description: D350-604-041 Rear locker extender.

Manufacture as per dwg D2273

Supplier: FDC Composites Inc.

Certification of Conformity and process sheet required.

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

FEB 03 2017

DAS
13
5-59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 156640

Friday, February 03, 2017 1:00:04 PM

156640

Page 2

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 11/16/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/14/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.05							
Small Fab	1- INSTALL DECALS AS PER DWG								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Friday, February 03, 2017 1:00:04 PM

156640

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Rear Locker Extender

Start Date: 11/16/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/14/2017 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

0.00

160

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: _____

PPP Rev: _____

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.02

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Friday, February 03, 2017 1:00:03 PM

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 11/16/2017**Required Date:** 12/14/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD
VERF:JLM IPP REV:X 17.01.12 AS PER CHG010 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2268		Manufactured	No			140	Each	13.0000	1	1			
D2268													
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		13							
				147069		7		6/13/2017					
				148553		6		7/22/2017					
D2269		Manufactured	No			155	Each	7.0000	1	1			
D2269													
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		7							
				147070		1		6/13/2017					
				148588		6		7/22/2017					
D2728-1		Manufactured	Yes			140	Each	0.0000	1	1			
D2728-1													
Dart Logo Label Small													
D350-604-041P		Purchased	No			110	Each	0.0000	1	1			
D.350-604-041P													
Rear Locker Extender													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Friday, February 03, 2017 1:00:03 PM

Page 2

Work Order ID: 156640

156640

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 11/16/2017

Required Date: 12/14/2017

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured

No

155

Each

16.0000

1

1

D5062-041

Bracket Assembly

Location

Loc Qty

Loc Code

ST147

16

145920

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

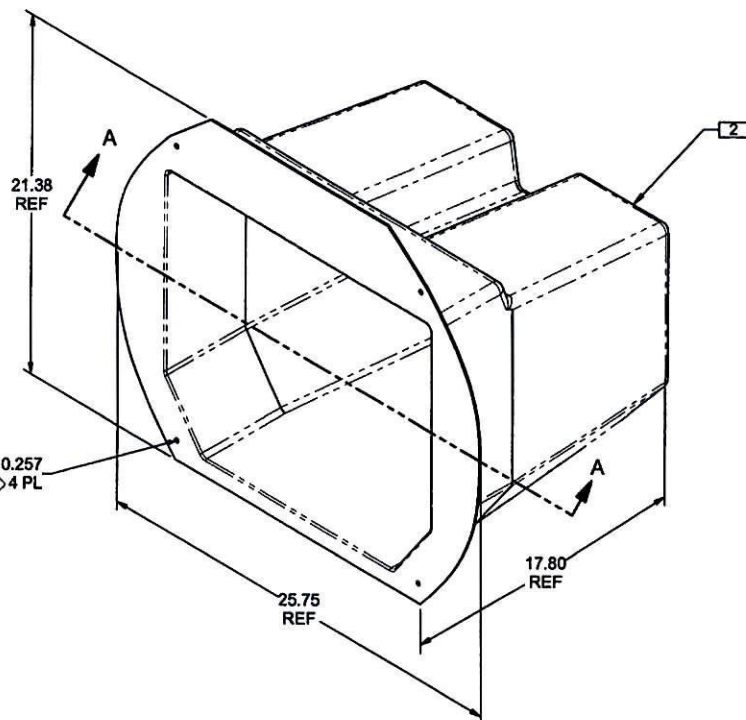


TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	55X3535 WHITE GELCOAT
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

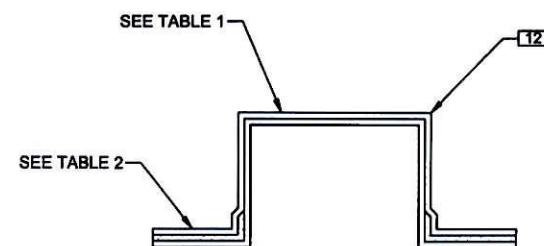
NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5- 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

DAS
13
9-09

FEB 03 2017

W/O: 156640



SECTION A-A

M	CHANGE GELCOAT TO 55X3535 WHITE GELCOAT, REMOVE PAINT FINISH OPTION (NOTE 2)	DB	16.05.19
L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	98.05.27
REV.	DESCRIPTION	BY	DATE

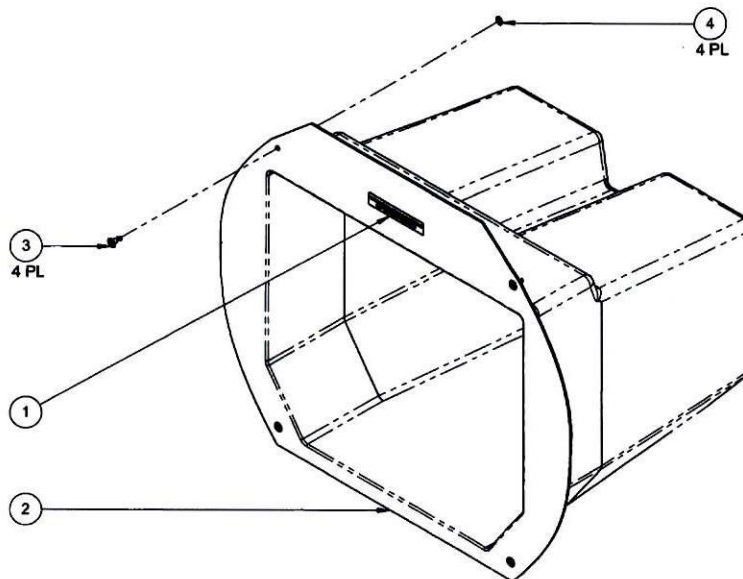
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. M
MFG. APPR.	DD	D2273	SHEET 1 OF
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	350 REAR LOCKER EXTENDER NT	
DATE	16.05.19	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

RELEASED
2017-01-11
EAW 17-501

APPROVED

COPYRIGHT © 1996 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
1	1	D2268	PLACARD
2	1	D2273	REAR LOCKER EXTENDER
3	4	2600-6	CAMLOCK STUD
4	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 5.5 to 7.5 lbs
- 8) INSTALL D2268 PLACARD IN LOCATION SHOWN, CENTERED ON FLANGE

C	REMOVE D2728-1, D2729-1 DECALS (ZN C5-1) REVISED RELATED NOTES, UPDATED PART WEIGHT	ML	13.12.16
B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS, ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1), ADD D2729-1 (ZN C5-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D350-604-041	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	RLE ASSY	NTS
DATE	14.01.02	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Gamme de fabrication

# LOT	2017-03-07
# SÉRIE(ID)	DAE001-131

Nom de Gamme :	Rear locker extender – DART
# de Gamme (et rev.) :	DAE001 Rev. E
Nom pièce – Client :	350 Rear locker extender – DART AEROSPACE
# de Dessins (et rev.) :	D2273 Rev. M

ID: B156640 #2

Fiche suiveuse

ÉTAPE	DESCRIPTION	DATE SORTIE
[10-50]	PRÉPARATION Moule, Espace de travail, Matières premières, Consommables	#21 #23 01 MAR. 2017 01 M/R. 2017
[60-80]	FINITION Appliquer Gelcoat, Inspecter	#3 07 MAR. 2017
[90-140]	MOULAGE Laminer, Démouler, Inspecter	#19 #23 07 MAR. 2017 07 MAR. 2017
[150-190]	USINAGE Percer, Découper, Ébavurer, Inspecter, Sabler	#30 9 MAR. 2017
[200-230]	FINITION Primer, Inspection	#3 28 MAR. 2017
240	EXPÉDITION Emballer, Expédier	#8 14 DEC. 2017

Gamme préparée par :	Guillaume G.Jasmin
Gamme vérifiée par :	Francis Lavigne-Larente
Gamme approuvée par :	Maxime Gagné
Date d'émission :	2015-01-14

Gamme révisé préparée par :	Pascal Séguin
Gamme révisé vérifiée par :	Karim Malihi
Gamme révisé approuvée par :	Michel Morin
Date de révision :	2017-02-22

Informations à remplir :

Cases grises pâles

Inspection :

Approbation Qualité
Avant de produire le CofC, toutes les étapes et les informations requises des gammes subséquentes reliées à ce produit ont été complétées et remplies

Inspecteur

31
Qualité

Matières premières

Résine	1028612	2017-05-17	Dion 7704
Norox (Résine)	41049	2017-08-01	MEKP-9
Norox (Gelcoat)	41049	2017-08-01	MEKP-9
Gelcoat blanc	702 407	2017-03-27	55X-3535
Mat ¾ oz/pi²	1505110074	N/A	¾ oz Chopped Strand Mat (Owens Corning Or Equivalent)
Fibre de verre 7725	4451515	N/A	Hexcel 7725 Fiber Glass
Apprêt (Primer) (Vert)	18584	2018-12-31	Tempo 4500-PB-23G (Vert)
Durcisseur pour apprêt (hardener)	18317	2018-05-01	Tempo 4500-C-23
Attache mécanique (Camloc)	508980	N/A	2600-5
Rondelle de retenue pour Camloc	1745658	N/A	2600-LW

Moule : MOU306 ou MOU309	FMS	Sarrau
Pompe à vide	55NC	Lunettes de sécurité
Jig de découpe et perçage CNC 5 axes	Peel ply	Soulier de protection
Jig de finition et d'inspection : GAB355	Film perforé	Gants
	Bleeder breather	Masques à cartouches
Pince pour installer Camloc : OUT951	Bag big blue	
Outil pour installer rondelle de retenue : OUT952	Ruban scellant (Dum Dum)	

Annexe 1
Formulaire de résine (RES-DAE001)

MPS-300-93-31-007-NC	Démoulage 55NC
MPS-300-93-31-058-A	Composite part inspection
MPS-300-93-31-020-B	Edge finish after trimming
MPS-300-93-31-097-NC	Epoxy - Polyamide primer
MPS-300-93-31-084-NC	Protection et entreposage des pièces

Suivi des révisions

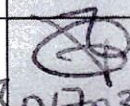
A	Révision d'une OP inspection, Ajout nouveaux moules et retrait d'un type de primer	2015-03-04	Guillaume G.Jasmin
B	Ajout des conformateurs, du gabarit GAB355, de l'installation des camlocs, inspection du poids et identification finale	2015-03-25	Guillaume G.Jasmin
C	Mise à jour de la case approbation qualité page 1	2015-04-02	Guillaume G.Jasmin
E	Changement de gelcoat, modification du format de la gamme, révision complète de la gamme	2017-02-22	Pascal Séguin

PRÉPARATION

10	<u>Remplir les informations requises sur la première page (cases gris pâle)</u> - Demander au coordonnateur de production (ID) - Inscrire les heures et les dates d'entrée et de sortie de département		#23 01 MAR. 2017	E : R :
20	<u>Découper la fibre et les périssables (Peel ply, sac étanche...) selon l'ANNEXE 1</u> - ACHEMINER et REMPLIR la section « Matière premières » pour : - Fibre de verre 7725 - Mat ¾ oz	Annexe 1	#23 01 MAR. 2017	E : R :
30	<u>Préparer la résine selon RES-DAE001 (Gamme de formulation de résine)</u> ACHEMINER et REMPLIR la section « Matière premières » pour : - Résine - Norox	RES-DAE001	#28 6 MAR. 2017	#28 7 MAR. 2017 E : R :
40	<u>Péparer le moule</u> - Cochez le moule utilisé : MOU306 ☐ / MOU309 ☒ ☒ Nettoyer et traiter le moule ☐ Poser le Masking tape <u>Si nécessaire, traiter le moule au 55NC</u> Faire le test de pelage, s'il ne passe pas, appliquer une couche de 55NC et refaire le test.	Annexe 1 MOU306 ou MOU309 MPS-300-93-31-007	#23 06 MAR. 2017	E : R :

50	<u>Préparer l'espace de travail (pendant l'application du gelcoat)</u>			#23 06 MAR. 2017	E: R:	
	☒ Vérifier et préparer la pompe ☒ Préparer et distribuer les outils ☒ Protéger l'environnement de travail (tables, plancher, etc.) ☒ Vêtir l'équipement de protection personnel ☒ Partir la ventilation ☒ Vérifier l'ordre et la présence de tous les plis de fibre et des morceaux de noyau dans le sac					
	Position	Matériel				Initial employé
	10F	¾ oz Chopped strand MAT				<i>mf</i>
	20F	7725 Fibre de verre				<i>mf</i>
	30F	7725 Fibre de verre				<i>mf</i>
	40R	7725 Fibre de verre				<i>mf</i>
	50R	7725 Fibre de verre				<i>mf</i>
	60R	7725 Fibre de verre				<i>mf</i>
70F	7725 Fibre de verre	<i>mf</i>				

FINITION

60	<u>ACHEMINER et REMPLIR la section « Matière premières » pour :</u>			#28 7 MAR. 2017	E: R:
	• Gelcoat blanc 55X-3535 • Norox MEKP-9				
70	<u>Appliquer le Gelcoat (18 - 22 mils)</u>		Annexe 1	#3 07 MAR. 2017	E: R:
	Heure d'application	06 h 45 min			
80	<u>Vérification de l'épaisseur du gelcoat lorsqu'encore humide</u>		Gauge d'épaisseur	 01703-07	E: R:

MOULAGE

90	Points d'inspection (Inspecteur Qualité ou Chef d'équipe) : ☒ Qualité de l'application du gelcoat : Uniforme et esthétique. ☒ Donner l'approbation pour que la pièce puisse être laminée (le gelcoat est « amoureux » ou « tack free »)		Inspecteur  Qualité 2017-03-07																															
100	LAMINER <table border="1" style="width: 100%;"> <thead> <tr> <th>Position</th> <th>Matériel</th> </tr> </thead> <tbody> <tr> <td>10F</td> <td>¾ oz Chopped strand MAT</td> </tr> <tr> <td>20F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>30F</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>40R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>50R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>60R</td> <td>7725 Fibre de verre</td> </tr> <tr> <td>70F</td> <td>7725 Fibre de verre</td> </tr> </tbody> </table> CONSOMMABLE <table border="1" style="width: 100%;"> <tbody> <tr> <td>10F</td> <td>Peel Ply</td> </tr> <tr> <td>20F</td> <td>Release film non perforé</td> </tr> <tr> <td>30F</td> <td>Bleeder / Breather</td> </tr> <tr> <td>50F</td> <td>Bagging bleu</td> </tr> </tbody> </table> ☐ S'assurer que tous les plis dans le tableau ont été laminés ☐ S'assurer que tous les conformateurs (Qte 9) sont en place par-dessus le Bleeder/Breather <table border="1" style="width: 100%;"> <tbody> <tr> <td>Heure début laminage</td> <td>7 h 20 min</td> </tr> <tr> <td>Heure mise sous-vide (sac scellé)</td> <td>8 h 20 min</td> </tr> <tr> <td>Intensité du vide (25 inHg)</td> <td>29</td> </tr> </tbody> </table>	Position	Matériel	10F	¾ oz Chopped strand MAT	20F	7725 Fibre de verre	30F	7725 Fibre de verre	40R	7725 Fibre de verre	50R	7725 Fibre de verre	60R	7725 Fibre de verre	70F	7725 Fibre de verre	10F	Peel Ply	20F	Release film non perforé	30F	Bleeder / Breather	50F	Bagging bleu	Heure début laminage	7 h 20 min	Heure mise sous-vide (sac scellé)	8 h 20 min	Intensité du vide (25 inHg)	29	Annexe 1 GAB356 à GAB364 (Qte 9)	#21 07 MAR 2017 #23 07 MAR 2017 #26 07 MAR 2017 #19 07 MAR 2017	E : R :
Position	Matériel																																	
10F	¾ oz Chopped strand MAT																																	
20F	7725 Fibre de verre																																	
30F	7725 Fibre de verre																																	
40R	7725 Fibre de verre																																	
50R	7725 Fibre de verre																																	
60R	7725 Fibre de verre																																	
70F	7725 Fibre de verre																																	
10F	Peel Ply																																	
20F	Release film non perforé																																	
30F	Bleeder / Breather																																	
50F	Bagging bleu																																	
Heure début laminage	7 h 20 min																																	
Heure mise sous-vide (sac scellé)	8 h 20 min																																	
Intensité du vide (25 inHg)	29																																	
110	LAISSER POLYMÉRISER la pièce sous vide pendant 2h #26 07 MAR 2017	#23 07 MAR 2017	#19 07 MAR 2017	E : R :																														
120	<u>DÉMOULER et IDENTIFIER la pièce</u> ☒ Brancher le système d'air comprimé ☒ Écrire le numéro de pièce et la date sur un collant – # de lot (date de début) – # de série ID Ex : (AAAAMMJJ) – (DAE001-XXX) ☒ Placer la pièce sur la table d'inspection	Annexe 1	#26 07 MAR 2017	E : R :																														

130	<u>Point d'inspection (inspecteur qualité) :</u> ☒ Identifier la présence de surplus de résine ☐ Identifier la présence de bulles d'air ☐ Identifier la présence de zone sèche ☒ Identifier la présence de plis dans la fibre	MPS-300-93-31-058	Inspecteur Qualité 2017-03-08	
140	<u>Nettoyer le moule</u> - Enlever la résine durcie tout le tour du moule avec une spatule en plastique pour ne pas endommager le moule <u>Si nécessaire</u>, nettoyer le moule avec un chiffon légèrement humecté de nettoyant à moule (PMC) NE PAS TROP APPLIQUER DE "PMC"	Spatule en plastique	2017-03-08	E: R:

USINAGE

				Temps réel
150	<u>PERÇAGE ET DÉCOUPE CNC 5 axes :</u> Utiliser le gabarit d'usinage et le programme d'usinage à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\21-Dessins & Outillage\Outillage\usinage 5 axes	Annexe 1	#30 9 MAR. 2017	E: R:
160	<u>SABLAGE :</u> - INSTALLER le Gabarit de finition et d'inspection GAB355 - SABLER la pièce jusqu'à arriver à la dimension du Gabarit GAB355 - ÉBAVURER les arêtes vives	GAB355 Annexe 1 MPS-300-93-31-020	N/A	E: R:
170	<u>Point d'inspection (inspecteur qualité) :</u> ☐ Plier les flanges (rebords) afin de s'assurer que le Gelcoat ne craque pas. (Voir Annexe 1 pour ce test) ☐ Vérifier la conformité de la pièce (Dimensions) selon le no. de dessin et selon le MPS-300-93-31-058	Annexe 1 MPS-300-93-31-058	Inspecteur Qualité 2017-03-16	
180	SABLER légèrement l'extérieur de la pièce Papier 120 à 320 grains		#19 13 MAR. 2017	E: R:
190	NETTOYER les surfaces extérieures		#3 28 MAR. 2017	E: R:

FINITION

200	APPLIQUER le primer 2 couches d'environ 10 mils chacune	MPS-300-93-31-097	#3 MARS 28 AVR. 2017	E : R :
210	Protéger le gelcoat Découper une pellicule de plastique protecteur bleu et la coller sur le rebord et à l'intérieur de la partie blanche (Gelcoat) (Voir Annexe 1)	Annexe 1	#19 2 MAI 2017	E : R :
220	INSTALLER les attaches mécaniques (Camlocs) (Qte 4) - Utiliser les pinces spécialisées (OUT951) pour insérer les Camlocs dans les trous - Utiliser l'outil spécialisé (OUT952) pour installer les rondelles de retenues	Annexe 1 Pince à Camloc (OUT951)	#19 2 MAI 2017	E : R :
230	Inspection finale : - Validation de la finition (pioches, surface inégale, etc...) - Vérifier s'il y a un panneau de contrôle relié à la pièce - Étamper le carré dans le coin inférieur droit de la première page - Poids de la pièce : <u>6.16</u> (lbs)	Annexe 1 MPS-300-93-31-058	 20170718	

EXPÉDITION

240	Identifier, emballer et expédier Identification selon le document DART QSI044 à l'emplacement suivant : Z:\PROGRAMMES\Dart Aerospace\Dart Aerospace Rear Lockers\22-Gammes de Fabrication\In process	MPS-300-93-31-084	#8 14 DEC. 2017	E : R :



©The information in this document is FDC (FDC composites inc.) Proprietary Information and is disclosed in confidence. If you are not the intended recipient you are hereby notified that any disclosure, copying, distribution or use of any of the information contained in or attached to this transmission is STRICTLY PROHIBITED.

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

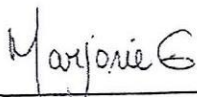
Customer P/O Number: 35200

Revision: A

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
1	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B156639	DAE001-129	2017-03-06
2	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B156640	DAE001-131	2017-03-07
3	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B156641	DAE001-132	2017-03-07
4	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B156642	DAE001-134	2017-03-08
5	1	D350-604-041P	D2273 Rev M	350 Rear Locker Extender	B156643	DAE001-136	2017-07-11

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Marjorie Geoffrion, Quality Inspector

Date: 2017-12-15

FDC Composites inc.
 45, Chemin de L'Aéroport
 Local 26
 Saint-Jean-sur-Richelieu (QC)
 J3B 7B5 **Tel.: 450 357-1344**

Customer: DAE-CAD

Dart Aerospace
 1270 Aberdeen Street
 Hawksbury, ON
 K6A 1K7

Invoice

14/12/2017

FDC2715

Reference : PO #35200/1-5
Terms : Net 30 jours/days

Ship To :

Dart Aerospace Ltd
 1270 Aberdeen Street
 Hawksbury, ON
 K6A 1K7 **Tel.: 1 613 632-9577**

Item No.	Description	Ord	Inv.	B/O Qty	Price	Total	Tx
D350-604-041P	REAR LOCKER EXTENDER PO item: 35200/1 Lot: 2017-03-06 As per DWG.D2273 Rev. M B156639	1	1	0	705.00	705.00	A
D350-604-041P	REAR LOCKER EXTENDER PO item: 35200/2 Lot: 2017-03-07 As per DWG.D2273 Rev. M B156640	1	1	0	705.00	705.00	A
D350-604-041P	REAR LOCKER EXTENDER PO item: 35200/3 Lot: 2017-03-07 As per DWG.D2273 Rev. M B156641	1	1	0	705.00	705.00	A
D350-604-041P	REAR LOCKER EXTENDER PO item: 35200/4 Lot: 2017-03-08 As per DWG.D2273 Rev. M B156642	1	1	0	705.00	705.00	A
D350-604-041P	REAR LOCKER EXTENDER PO item: 35200/5 Lot: 2017-07-11 As per DWG.D2273 Rev. M B156643	1	1	0	705.00	705.00	A

Subtotal : 3 525.00

TVH-Ont. : 458.25

A) Regist : 83343 3220 RT0001

Total : 3 983.25